



## Case Study

### Cost-Effective Heat Recovery System Delivers Energy, Financial and Environmental Benefits For Nestle Inc.

The Nestle Canada, Chambly, Quebec plant processes confectionery, coffee and beverage products primarily. As a result, Nestle operates at high efficiency. Nestle Canada is always looking for ways to conserve energy, reduce emissions and lower operating costs. In pursuit of their energy efficiency goals, Nestle Canada contacted Combustion & Heating Systems to investigate potential energy recovery solutions.



The project plant consists of a package boiler producing 600,000 lb/hr of steam and a 40,000 lb/hr boiler heating spent coffee grounds. The energy investigation conducted by Combustion & Heating Systems revealed the availability of recoverable heat energy being exhausted as well as the existence of heat heat sinks that were consuming 100% purchased energy.

Because the spent coffee grounds are dried before they are burned, the dryers exhaust represent a lot of the heat source of recoverable heat. The challenge resided in the effective and efficient extraction of energy.

Initial testing was done to determine the properties for the design criteria. The tests revealed that the dryer exhaust gas contained 99.4% water by volume with 0.001 lb/lb particulate. Based on this data, a Chubbs system was designed to heat boiler make up water from 60°F to 170°F. The exhaust gas temperature is lowered from 1,000°F to 120°F and the heat transferred is 1,900,000 Btu/hr. The system consumes 1,900 lb/hr of water from the exhaust gas. In addition to the Chubbs system for dryer exhaust heat recovery, the project also included the installation of a condensate separator, which utilized the waste heat from the package boiler.



The complete energy recovery solution provided by the Chubbs Systems results in yearly fuel savings in excess of \$1,000,000.00. The installed cost payback for the system was less than 12 months. The reductions in fuel being burned also reduces the plant emissions of CO<sub>2</sub> and SO<sub>2</sub>, substantially. Chubbs energy recovery systems can recover both latent and sensible heat from boiler, dryer, steam, steam, furnaces or any fuel producing exhaust gas.

# Condex Condensing Economizer Operating Manual

**R Pring**

## **Condex Condensing Economizer Operating Manual:**

Consider Installing a Condensing Economizer ,2007 One in a series of tip sheets to help manufacturers optimize their industrial steam systems    **Condensing Economizers for Thermal Efficiency Improvements and Emissions Control** ,1993 Flue gas condensing economizers improve the thermal efficiency of boilers by recovering sensible heat and water vapor latent heat from flue gas exhaust In addition to improving thermal efficiency condensing economizers also have the potential to act as control devices for emissions of particulates SO subscript x and air toxics Both Consolidated Edison of New York and Brookhaven National Laboratory are currently working on condensing economizer technology with an emphasis on developing their potential for emissions control Con Edison is currently conducting a condensing economizer demonstration at their oil fired 74th Street Station in New York Since installing this equipment in February of 1992 a heat rate improvement of 800 Btu kWh has been seen At another location Ravenswood Station a two stage condensing economizer has been installed in a pilot test In this advanced configuration the Integrated Flue Gas Treatment or IFGT system two heat exchanger sections are installed and sprays of water with and without SO<sub>2</sub> sorbents are included Detailed studies of the removal of particulates SO<sub>2</sub> SO<sub>3</sub> and selected air toxics have been done for a variety of operating conditions Removal efficiencies for SO<sub>2</sub> have been over 98% and for SO<sub>3</sub> over 65% Brookhaven National Laboratory's studies involve predicting and enhancing particulate capture in condensing economizers with an emphasis on small coal fired applications This work is funded by the Pittsburgh Energy Technology Center of the Department of Energy Flyash capture efficiencies as high as 97% have been achieved to date with a single stage economizer

Considerations When Selecting a Condensing Economizer ,2007 One in a series of tip sheets to help manufacturers optimize their industrial steam systems    *Condensing Economizers for Small Coal-fired Boilers and Furnaces* ,1994 Condensing economizers increase the thermal efficiency of boilers by recovering sensible and latent heat from exhaust gas These economizers are currently being used commercially for this purpose in a wide range of applications Performance is dependent upon application specific factors affecting the utility of recovered heat With the addition of a condensing economizer boiler efficiency improvements up to 10% are possible Condensing economizers can also capture flue gas particulates In this work the potential use of condensing economizers for both efficiency improvement and control of particulate emissions from small coal water slurry fired boilers was evaluated Analysis was done to predict heat transfer and particulate capture by mechanisms including inertial impaction interception diffusion thermophoretic forces and condensation growth Shell and tube geometries were considered with flue gas on the outside of Teflon covered tubes Experimental studies were done with both air and water cooled economizers refit to a small boiler Two experimental arrangements were used including oil firing with injection of flyash upstream of the economizer and direct coal water slurry firing Firing rates ranged from 27 to 82 kW 92 000 to 280 000 Btu hr Inertial impaction was found to be the most important particulate capture mechanism and removal efficiencies to 95% were achieved With the addition of water sprays directly on

the first row of tubes removal efficiencies increased to 98% Use of these sprays adversely affects heat recovery Primary benefits of the sprays are seen to be the addition of small impaction sites and future design improvements are suggested in which such small impactors are permanently added to the highest velocity regions of the economizer Predicted effects of these added impactors on particulate removal and pressure drop are presented *Engineering evaluation of the use of the timberline condensing economizer for particulate collection ,1980*

### **Condensing Economizers for Efficiency**

**Improvement and Emissions Control in Industrial Boilers** ,1996 Condensing economizers recover sensible and latent heat from boiler flue gas leading to marked improvements in thermal efficiency This paper summarizes the current commercial status and continuing development efforts with one type of condensing economizer In this design Teflon reg\_sign covered tubes and enclosure walls are used to handle the corrosive condensate Flue gas flows around the tubes and feed water being heated flows through the inside In addition to improving thermal efficiency condensing economizers can also be used to reduce particulate emissions primarily by inertial impaction of particles on tube surfaces water droplets and added impactors Collected particles are then removed with condensate Water sprays directly on the tubes can be used to enhance particle capture With coal firing tests have shown particle removal efficiencies as high as 98% To enhance the emissions control potential of condensing economizer technology a two stage economizer system concept has been developed Two heat exchanger modules are used The first is a downflow design and recovers primarily sensible heat from the flue gas The second is upflow and recovers mostly latent heat Condensate is collected in a transition plenum between the two stages This configuration termed the Integrated Flue Gas Treatment System provides great flexibility for implementing emissions reduction strategies Particulate emissions can be reduced without impacting sensible heat recovery by recirculating collected condensate to spray nozzles at the top of the second stage heat exchanger In tests at BNL with heavy oil firing particulate reductions over 90% and final emission rates on the order of 005 lb MMBtu are achieved Adding sorbents to the recirculated condensate reduces sulfur dioxide emissions and SO2 removal efficiencies over 95% are achieved Also condensing economizers show great potential for the removal of certain air toxics such as mercury and nickel

**Condensing Economizers for Small Coal-fired Equipment** ,1994 Condensing economizers can be used to increase the thermal efficiency of boilers and furnaces This study focuses on evaluating indirect contact economizers as applied to heating equipment burning coal water mixtures although the results can be extended to other fuels In addition to dry gas sensible heat latent heat is recovered from flue gas water vapor improving system efficiency markedly In addition to improving thermal efficiency condensing economizers can also capture particulates In tests to date up to 98% total removal has been measured The primary objectives of this project are to evaluate the most important mechanisms involved in particle capture and to enhance capture in practical systems The intent of the work is to contribute to the ongoing program at the Department of Energy Pittsburgh Energy Technology Center in the development of coal fired combustion equipment These

results are expected to be most applicable to smaller scale equipment where the low temperature heat from the economizer can be used. However, interest in the use of condensing economizers for industrial and utility applications is increasing and this work certainly is relevant in these sections also. The approach involves determining thermal efficiency improvement and particulate removal efficiency experimental and developing models capable of predicting system performance under varied operating conditions. Theoretical Gas temperature and condensation profiles through the economizers have been predicted and overall predicted performance are consistent with test results. Mechanisms for particle removal are discussed in this paper and predicted removal efficiencies as a function of particle diameter are presented

**CONDENSING  
ECONOMIZERS FOR SMALL COAL-FIRED BOILERS AND FURNACES PROJECT REPORT - JANUARY 1994**, 1994

Condensing economizers increase the thermal efficiency of boilers by recovering sensible and latent heat from exhaust gas. These economizers are currently being used commercially for this purpose in a wide range of applications. Performance is dependent upon application specific factors affecting the utility of recovered heat. With the addition of a condensing economizer, boiler efficiency improvements up to 10% are possible. Condensing economizers can also capture flue gas particulates. In this work, the potential use of condensing economizers for both efficiency improvement and control of particulate emissions from small coal water slurry fired boilers was evaluated. Analysis was done to predict heat transfer and particulate capture by mechanisms including inertial impaction, interception, diffusion, thermophoretic forces and condensation growth. Shell and tube geometries were considered with flue gas on the outside of Teflon covered tubes. Experimental studies were done with both air and water cooled economizers refit to a small boiler. Two experimental arrangements were used including oil firing with injection of flyash upstream of the economizer and direct coal water slurry firing. Firing rates ranged from 27 to 82 kW, 92 000 to 280 000 Btu hr. Inertial impaction was found to be the most important particulate capture mechanism and removal efficiencies to 95% were achieved. With the addition of water sprays directly on the first row of tubes removal efficiencies increased to 98%. Use of these sprays adversely affects heat recovery. Primary benefits of the sprays are seen to be the addition of small impaction sites and future design improvements are suggested in which such small impacts are permanently added to the highest velocity regions of the economizer. Predicted effects of these added impactors on particulate removal and pressure drop are presented.

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